



Date: Tuesday, 01/05/2007 2:25:50 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 31863 -1
 Estimate Number : 12675
 P.O. Number : N/A
 This Issue : 01/05/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 31863
 Written By : 
 Checked & Approved By : 
 Comment : Est Rev:A New Issue 07-01-29 JLM

Drawing Name : ADAPTER
 Part Number : D35735
 Drawing Number : D3573 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 13/05/2007

SPLIT

Qty: 29 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X02500	6061-T6 Bar .50" x 2.5"
-----	--------------------	-------------------------



Comment: Qty.: 0.3066 f(s)/Unit Total: 18.3960 f(s)
 6061-T6 Bar .50" x 2.5"
 Batch: M103433

SA 07.05.05

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank 3.250" long

SA 07.05.05 (31)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA674 and Dwg D3573

SA 07.05.06 (29)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.05.06 29

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

m-l 07/05/09 29

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

m-l 07/05/10 (29X)

Date: Tuesday, 01/05/2007 2:25:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 31863

Part Number: D35735

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

esl

07-05-11

(29)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/5/14

(28)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SE 244

PC 7/5/14

7/5/14

SL

(29)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PC 07/05/15

(29)

Job Completion



07-05-15



Date: Tuesday, 4/17/2007 11:13:28 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ADAPTER
Job Number : 31863	
Estimate Number : 12675	
P.O. Number :	Part Number : D35735
This Issue : 4/17/2007 S.O. No. :	Drawing Number : UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : U/R
Previous Run : 30629	Material :
Written By :	Due Date : 5/12/2007 Qty: 60 Um: Each
Checked & Approved By :	
Comment : Est Rev A New Issue 07-01-29 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0500X02500	6061-T6 Bar .50" x 2.5"
-----	--------------------	-------------------------



Comment: Qty.: 0.3066 f(s)/Unit Total : 18.3960 f(s)
 6061-T6 Bar .50" x 2.5"
 Batch: _____

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank 3.250" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA674 and Dwg D3573

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK






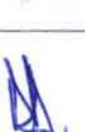


6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/06	3.0	1 part scrap. Origin off -200. Error on Lolio		destroy part	SD 07.03.07	 07/05/09		 07/05/09
07/03/06	3.0	1 part scrap. Part too thin. Error in program.		destroy part	SD 07.03.07	 07/05/09		 07/05/09

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:13:29 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 31863

Part Number: D35735

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

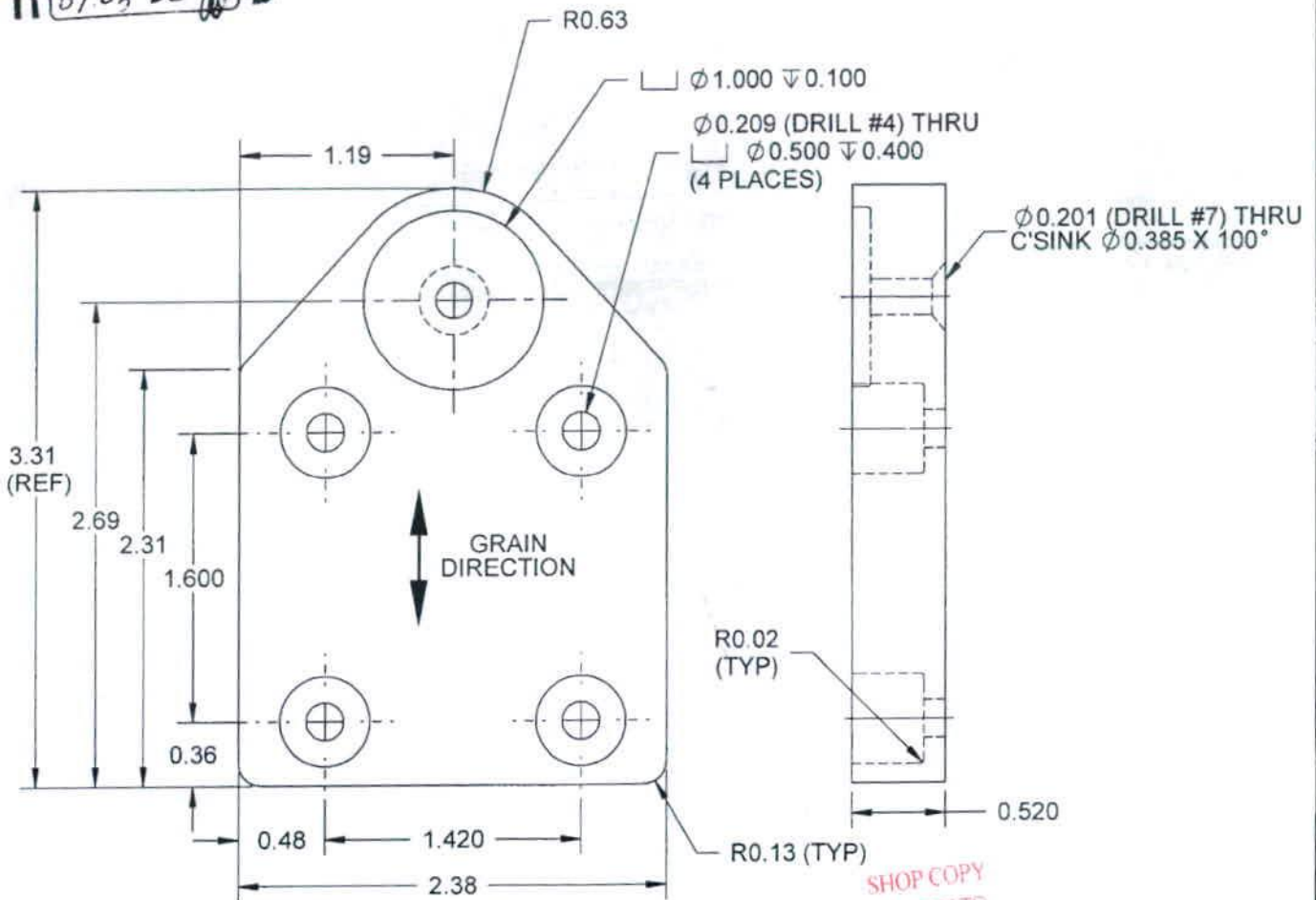
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

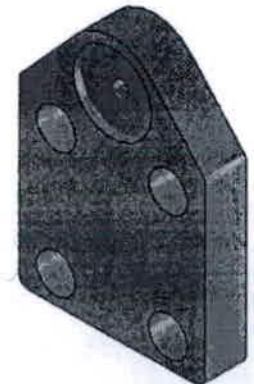
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 1 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE	

RELEASED
07.03.22**D3573-1 ADAPTER**

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **31863**

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

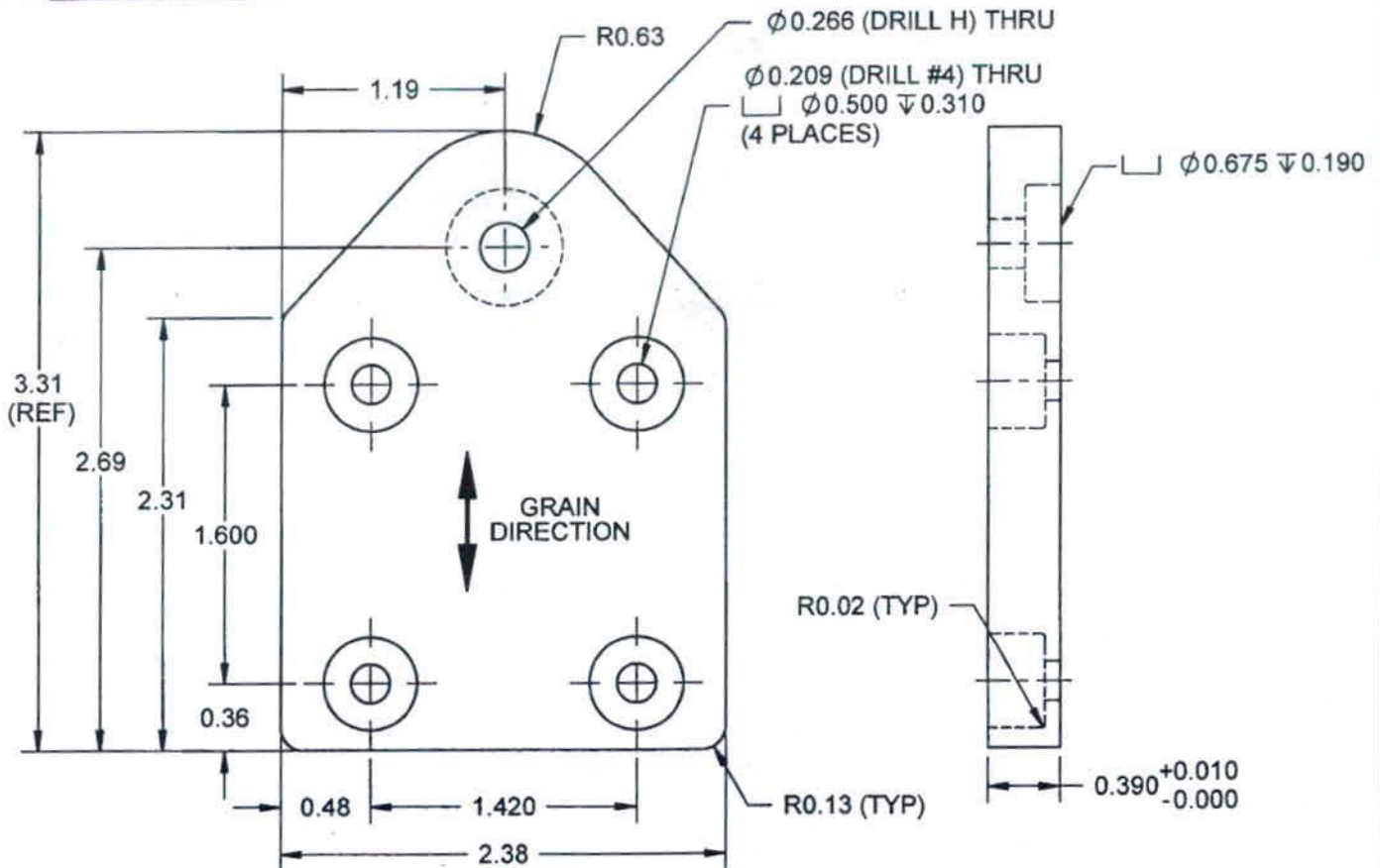


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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 2 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02**D3573-3 ADAPTER**

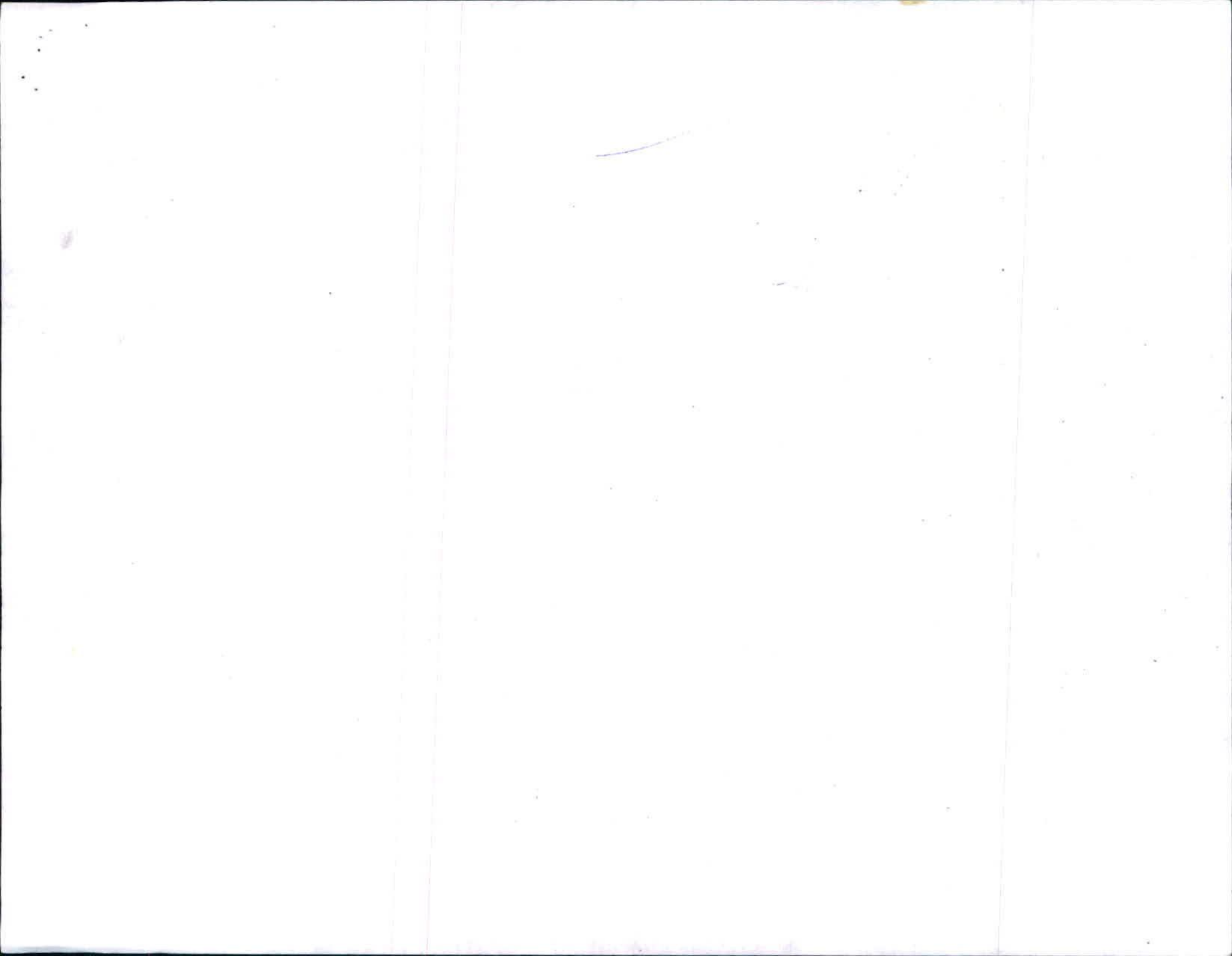
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WITHOUT NOTICE
WORK ORDER
NO. 31863

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

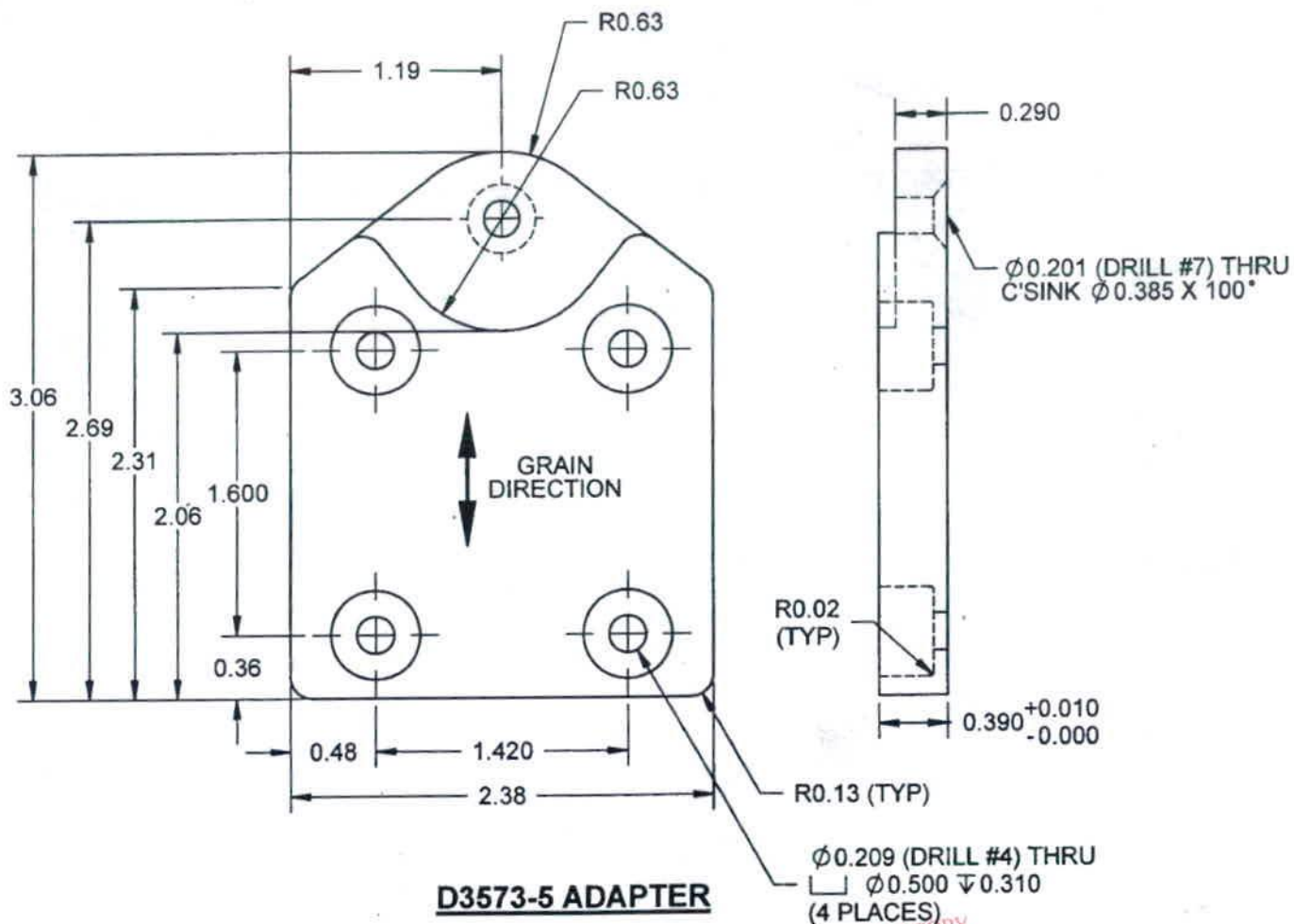
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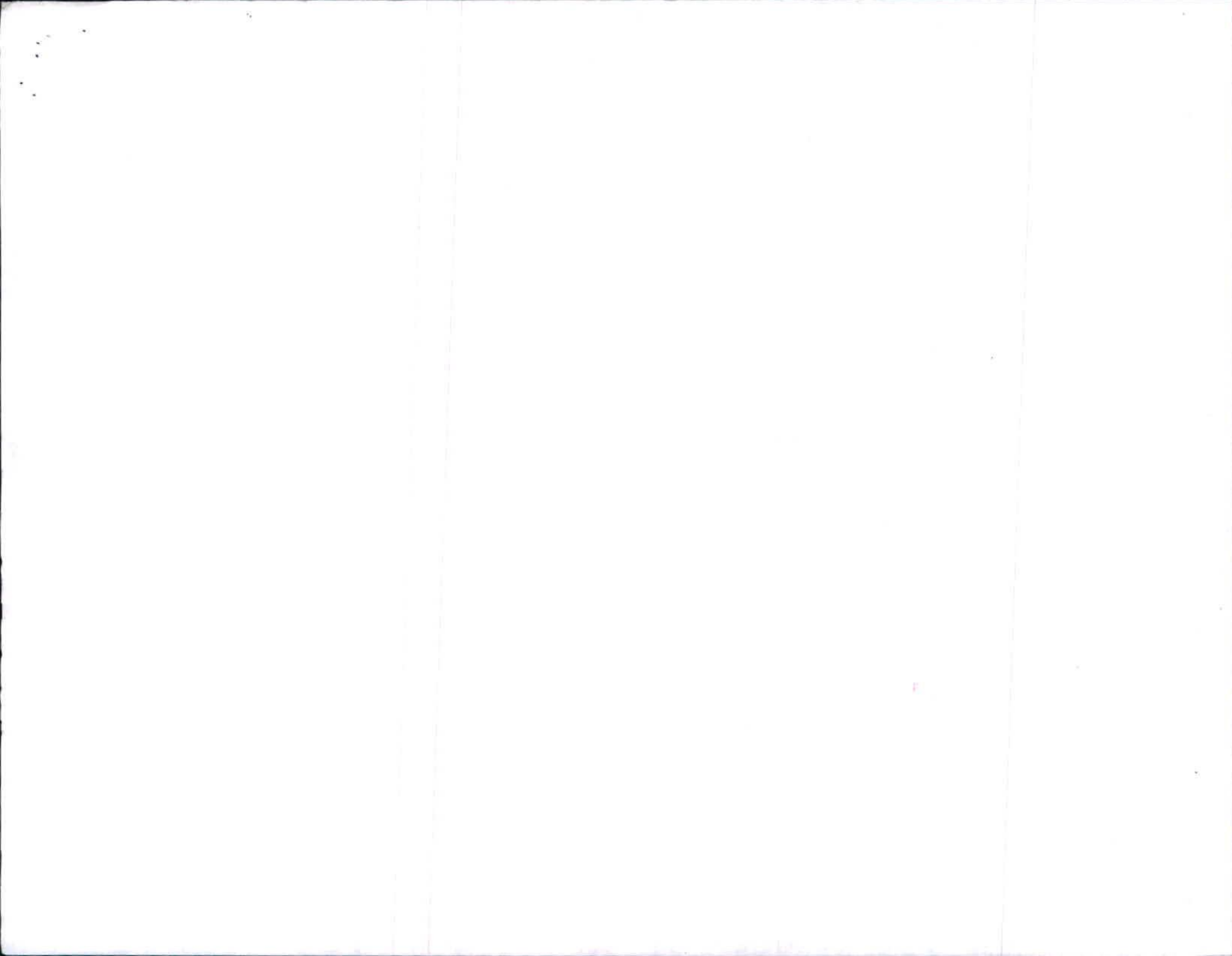
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 3 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

RELEASED
07.04.02**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

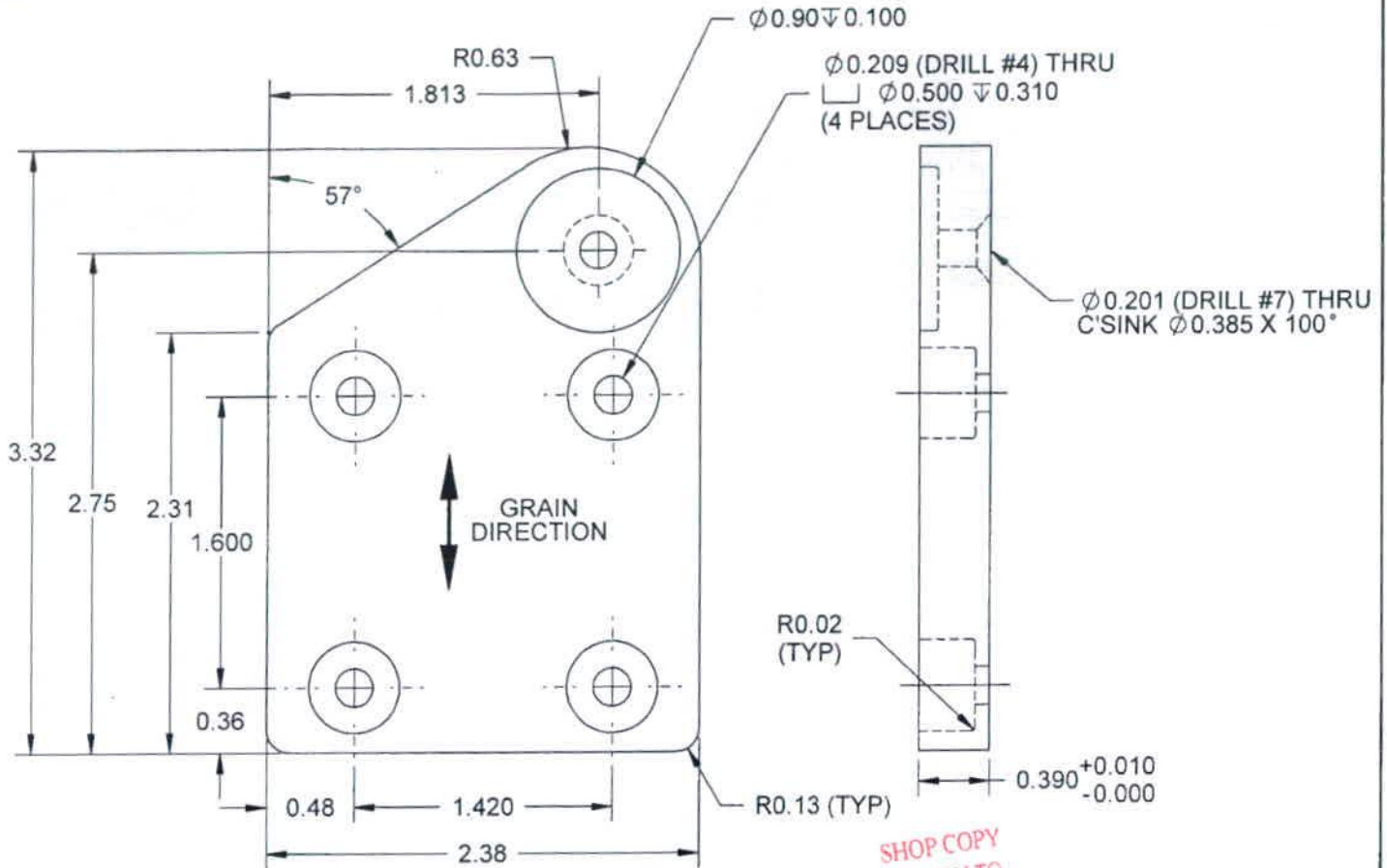
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

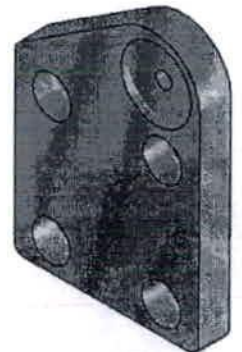
RELEASED
07.04.02

D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

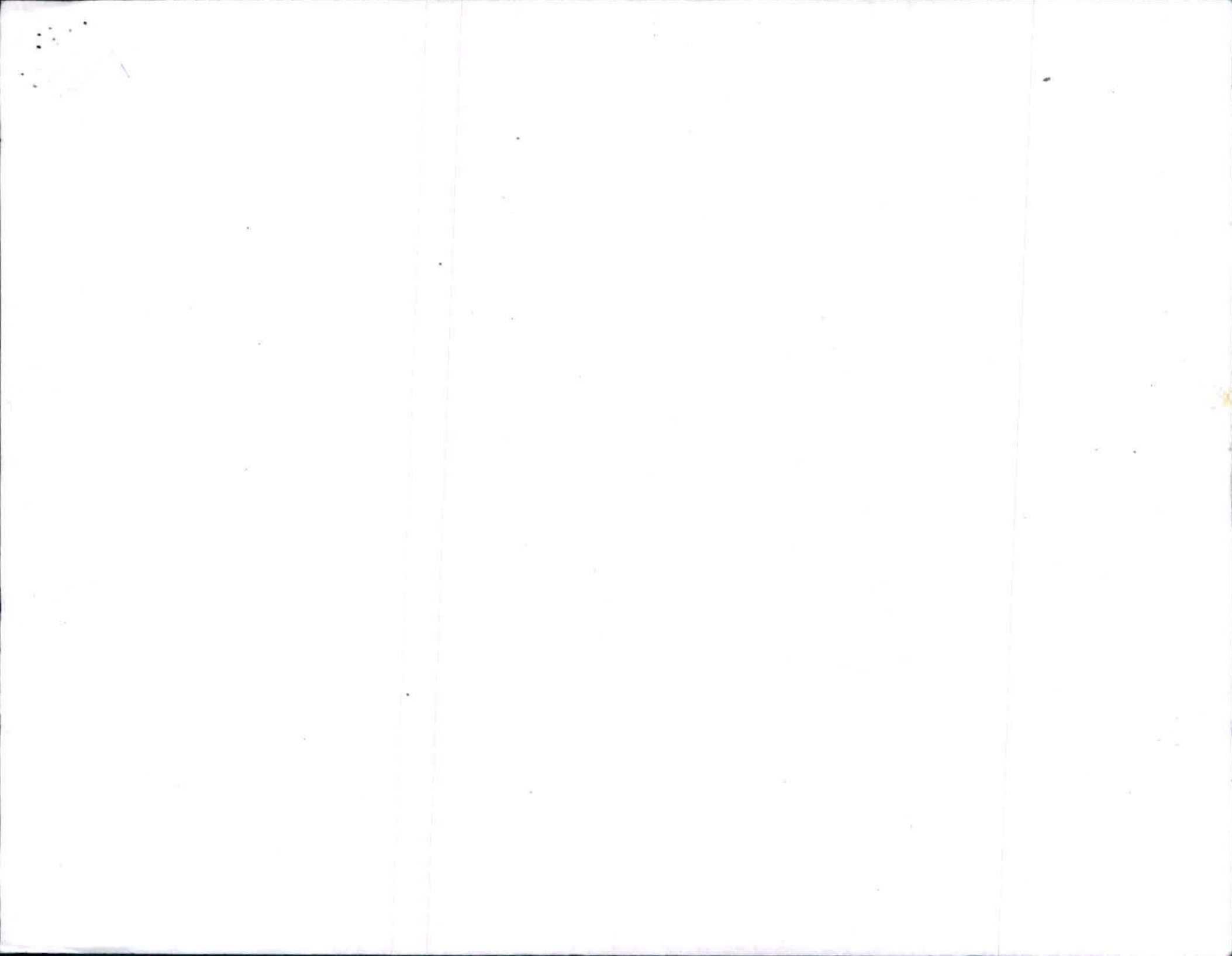
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WORK ORDER
NO. **31863**

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 31863
Description: Adapter		Part Number: 13573-5
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.06	$\pm .030$	3.064	/			
2.69	$\pm .030$	2.694	/			
2.31	$\pm .030$	2.31	/			
2.06	$\pm .030$	2.064	/			
1.600	$\pm .010$	1.600	/			
.36	$\pm .030$.359	/			
.48	$\pm .030$.480	/			
1.420	$\pm .010$	1.420	/			
2.38	$\pm .030$	2.378	/			
1.19	$\pm .030$	1.190	/			
R.13	$\pm .030$	R.125	/			
Ø .209	$\pm .005$ $\pm .001$.211	/			
Ø .500 C-had	$\pm .010$.497	/			
Ø .310	$\pm .010$.313	/			
.390	$\pm .010$ $\pm .000$.397	/			
.290	$\pm .010$.297	/			
Ø .201	$\pm .005$ $\pm .001$.203	/			
Ø .385x100	$\pm .010$	Ø .383x100	-			

Measured by: SD	Audited by: ml	Prototype Approval: LE
Date: 07-05-06	Date: 07/05/09	Date: 07-05-09

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

